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D407-547-047
Job Sheet 182592



Part No: D407-547-047

Job Qty: 1 ea

Part Name: Console High Slope



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/28/18

Job Tracking No:

Due Date: 9/7/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D206-547 REV F Sheet 1,5 IPP Rev:1 06-01-05 Removed Packing Kit JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	9/7/18	9/7/18	0.00	0.00	Start Up Small Fab-3		DAS 58 9-89 18/9/18
100	Small Fab	1 pcs	9/7/18	9/7/18	0.00	0.93	Small Fab-5		DAS 38 9-89
130	QC	1 pcs	9/7/18	9/7/18	0.00	0.00	QC5		1BC 38 9-89
140	Large Fab	1 pcs	9/7/18	9/7/18	0.00	0.39	Large Fab 2		1BC 38 9-89
150	QC	1 pcs	9/7/18	9/7/18	0.00	0.00	QC10		1BC 38 9-89
160	Small Fab	1 pcs	9/7/18	9/7/18	0.00	0.93	Small Fab-5		Smb DAS 68 9-89
170	QC	1 pcs	9/7/18	9/7/18	0.00	0.00	QC5		SEP 20 2018 68 9-89
180	Powdercoat	1 pcs	9/7/18	9/7/18	0.00	0.16	Powdercoat4		SEP 24 2018 68 9-89
190	QC	1 pcs	9/7/18	9/7/18	0.00	0.00	QC3		SEP 24 2018 68 9-89
200	Packaging	1 pcs	9/7/18	9/7/18	0.00	0.00	Packaging3-2		SEP 24 2018 68 9-89
210	QC21-FG	1 Ea	9/7/18	9/7/18	0.00	0.00	QC21		1BC 18-09-24

Part Op 100 - 1-Cut D2710-1, D2710-2, D2710-3, D2710-4 from D2024 Extrusion as per Dwg D2710 and templates DT 8264-1, Descriptions: DT 8264-2, DT8264-3, DT8264-4 2-Debur 3-Grind weld relief chamfer as per Dwg D206-547 4- Clean rails with ultra bright aluminum cleaner before riveting 5- Rivet extrusion to sides as per Dwg D206-547 using Rivet MS20470AD3-4 140 - 1-Weld as per Dwg D206-547 A/R AL ROD Batch: 134985 2-Grind weld as per dwg D206-547 160 - 1-Rivet sides and brackets per Dwg D206-547 using Rivet MS20470AD3-3 180 - START TIME: 7:00 OVEN TEMPERATURE: 520 FINISH TIME: 8:20

M 134985

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2024	Extrusion (\$ Per Square Foot)	3.4200 Ea (3.42 ea)	90-Start up Operation	3037715
D2604-1	Console Side LH, 407 Console	1 Ea (1 ea)	100-Small Fab	5037710
D2604-2	Console Side RH, 407 Console	1 Ea (1 ea)	100-Small Fab	5037710
D2606	Console Bracket, 206/407 Console	1 Ea (1 ea)	100-Small Fab	F16350
D2608	Bracket, 407 Console	1 Ea (1 ea)	100-Small Fab	5112056
MS20470AD3-3	Rivet, Universal Head	6 Ea (6 ea)	100-Small Fab	F16941
MS20470AD3-4	Rivet, Universal Head	20 Ea (20 ea)	100-Small Fab	fm1344540

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2024	3	991	0
100-Small Fab	D2604-1	1	1	0
	D2604-2	1	1	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

D2606	1	3	0
D2608	1	0	0
MS20470AD3-3	6	5,657	0
MS20470AD3-4	20	6,641	0

Part Specifications

Specifications could not be found.

Plex 8/29/18 7:01 AM Dart.lajeunesse.marie

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AEROSPACE

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Container No: S110989



Part: D407-547-047

Job No: 182592

Serial No/Batch: S110989

Revision: F

Inspector:

Exp Date:

Instructions: Various STC's

Date: 09/18/18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			Completed By
					Lead hand / Supervisor Approval Verification
					QC / QA Coordinator Approval
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		OTHER : ☐	